

# Work Order ID 87012

**\*87012\***

Page 1

Monday, July 09, 2012 3:49:33 PM

Item ID: D350-636-014

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *7/10/12* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D2750

F

D3492

C *SP*

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

*DAS 16 7/10/12*

*for MLJ 12-7-26*

**87012**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*1\***

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Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

**\*110\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

*BE 12/07/12*

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

*BE 12/07/12*

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

*7 SAD 12-07-13*

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

*BE 12/07/12*

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B. \*\*\*SECOND SIDE\*\*\*

*SAD 12-07-13*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

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Item ID: D350-636-014

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 7/10/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M12230 BE 12/07/12

12-Grind welds flush as per Dwg D2750 BE 12/07/12

120

QC10- Inspect visual per QSI004- ground welds

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Item ID: D350-636-014

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

1 76 12-7-16

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

DP 12-7-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

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**\*NS1\***

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Item Name: Skidtube RH

Stop

**\*NS2\***

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**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

**\*160\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding. remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 122130

exp. date: 13-3-14 - DC 12/07/18

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: M122130

BE 12/07/20

8-Grind welds flush as per Dwg D2750

SAD 12-07-23

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

DC 12/07/18

12/07/23

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

DAS  
16  
9-89 12/14/14DAS  
16  
9-89 12/14/14

70

1 76 12-7-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 87012**

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Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Powder Coating

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

Inspect for foreign object per QSI 024

0.00

Quality Control

IX  12/07/25

IRK  (2P) 12/07/25

m121841

8-30  
3200 F  
9-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 87012

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Item ID: D350-636-014

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**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 110348

3-Assemble tube hardware as per dwg D2750 sikaflex batch: 122130

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe  
SIKA FLEX 241

BATCH: 122130  
EXP DATE: 14/07

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 110348

8-Coat all exposed fasteners with "LPS Procyon" batch: 114596

1 RH Q BP 12/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 87012**

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**\*87012\***

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Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

DAS  
16  
9-89

12/4/26

1/4

SP  
12-7-27DAS  
16  
9-89

12/4/27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

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Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-014

*I**6/12/12*

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*12/7/30**12/20/27*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Page 1

Work Order ID: 87012  
Parent Item: D350-636-014  
Parent Item Name: Skidtube RH

Start Date: 7/10/2012  
Start Qty: 1.00

Required Date: 7/24/2012  
Required Qty: 1.00

12

Comments: IPP Rev:H02.09.25Rearranged procedure stepsKJ  
IPP Rev:I05.12.08Rearranged procedure stepsEC  
IPP Rev:J06.03.30Per rev. D EC  
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N 10.06.22 revise seq110  
DD verf:EC IPP Rev:O 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 Insert		Purchased	No			230	Each	2,888.0000	38	38	38	12/07/25	

## Location

## Loc Qty

## Loc Code

FP-B	2445	
122290 ✓	2445	
ST281	420	
108696	146	
110768	62	
118386	55	
118966	68	
121269	89	
ST282	23	
120410	10	
120451	13	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,611.0000 34 34 34 12/07/25

Location	Loc Qty	Loc Code
FP001	7	
115835	7	
ST350	1604	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121255 ✓	469	16
121444	34	
121708	500	
122141 ✓	500	18

AN3C6A Purchased No 230 Each 285.0000 4 4 4 12/07/25

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	284	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	118	
121682 ✓	74	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Page 3

Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 104.0000

BOLT

4 12/07/25

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST343	102	
121013	11	
121440	41	
122204 ✓	50	

AN8C21A Purchased No

BOLT

250 Each 77.0000

2 12/07/25

Location	Loc Qty	Loc Code
ST343	77	
118758	3	
121275	24	
122204 ✓	50	

AN8C35A Purchased No

BOLT

230 Each 61.0000

1 12/07/25

Location	Loc Qty	Loc Code
FP002	60	
115960	1	
118286	9	
121275 ✓	50	
ST346	1	
114442	0	
115188	0	
115960	1	

AN960C10L \*NASI149C0332R ✓ Purchased No

washer

230 Each 21.0000

38 38 12/07/25

Location	Loc Qty	Loc Code
ST	21	
107534	21	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each 33.0000

1

1

Extrusion Bent

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	33	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
86330	17	

BE 12/07/11

D2739

Manufactured No

160 Each 14.0000

1

1

350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	14	
72155	1	
81508	1	
83448	2	
83548	1	
85486	5	
86615	4	

DC 12/07/18

D2741

Manufactured No

250 Each 34.0000

1

Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	
ST466	44	
71856	1	
83135	33	

SP 12-7-216

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2743  
Crossbolt Spacer

Manufactured No

160 Each 152.0000 8 8

BE 12/07/20  
885459 x8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	78	
81965	23	
83262	55	
LG001	74	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

D2744  
Cap

Manufactured No

160 Each 60.0000 1 1

BE 12/07/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	60	
62715	1	
83412	21	
85506	38	

D2745  
Bushing

Manufactured No

230 Each 258.0000 8 8

8 (2P) 12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	206	
79518	6	
85416 ✓	200	
FP001	52	
69529	1	
76142	1	
83260	50	

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-042  
Blade Fitting Assembly, RH

Manufactured No

230 Each 28.0000

1 1 12/07/25

Location	Loc Qty	Loc Code
FP	-1	
83417	11	
FP002	29	
85734 ✓	5	
86054	12	

D3490-1  
Cross Bolt Spacer

Manufactured No

160 Each 79.0000

4 4 8/12/07/20

Location	Loc Qty	Loc Code
LG	68	
81976	2	
85419	66	
LG001	11	
62450	2	
74875	4	
77042	3	
83269	2	

D3490-5  
Cross Bolt Spacer

Manufactured No

160 Each 31.0000

4 4 8/12/07/20

Location	Loc Qty	Loc Code
LG001	31	
83373	31	

D3492-1  
Plug

Manufactured No

230 Each 205.0000

8 8 12/07/25

Location	Loc Qty	Loc Code
FP002	198	
69531	8	
74444	2	
76235	4	
83259 ✓	184	
FP-A	7	
83098	7	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Page 7

Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5 Plug Manufactured No 230 Each 135.0000 8

Location	Loc Qty	Loc Code
fpa	135	
83100 ✓	34	
83530	101	

8 8 12/07/25

D3493-1 Washer Manufactured No 250 Each 97.0000 2

Location	Loc Qty	Loc Code
ST050	97	
77573	1	
82023	2	
83097	94	

2 2 12/07/25

D3535-25 Wearshoe Manufactured No 230 Each 32.0000 1

Location	Loc Qty	Loc Code
FP001	32	
62233	1	
81357	1	
83387	17	
83899 ✓	13	

1 2x 12/07/25

D3536-25 Gasket Manufactured No 230 Each 22.0000 1

Location	Loc Qty	Loc Code
FP	22	
83391	6	
83900 ✓	16	

1 1 12/07/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 8

Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No  
Wearpad

230 Each 112.0000

3 3 12/07/25

Location	Loc Qty	Loc Code
FP002	112	
81362	3	
83254	1	
83255	3	
83256	20	
85457 ✓	37	
85458	48	

D3631-1 Manufactured No  
Washer

230 Each 283.0000

8 8 12/07/25

Location	Loc Qty	Loc Code
FG	268	
81874	2	
83588 ✓	266	
ST072	15	
68062	2	
75548	13	

D3791-1 Manufactured No  
Wearplate

230 Each 26.0000

1 1 12/07/25

Location	Loc Qty	Loc Code
FP002	26	
62239	2	
83392	12	
83902 ✓	12	

D3793-1 Manufactured No  
Wearshoe

230 Each 26.0000

1 1 12/07/25

Location	Loc Qty	Loc Code
FP001	26	
82171	2	
83393	11	
83903 ✓	13	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3	Manufactured	No	230	Each	28.0000	1	1	12/07/25
Wearshoe								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		FP001	28					
		83394 ✓	16					
		83901	12					
D3794-1	Manufactured	No	230	Each	24.0000	1	1	12/07/25
Gasket								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		FP	4					
		82167	4					
		FP002	20					
		83395 ✓	20					
D3794-3	Manufactured	No	230	Each	45.0000	1	1	12/07/25
Gasket								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		FP	19					
		83396 ✓	19					
		FP002	26					
		74530	2					
		86243	24					
MS21043-6	Purchased	No	230	Each	586.0000	4	4	12/07/25
NUT								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		FG	20					
		103693	20					
		ST301	566					
		117887	2					
		118384 ✓	64					
		120308	500					

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 10

Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

94.0000

1

NUT

## Location

## Loc Qty

## Loc Code

304

39

121185 ✓

22

121349

17

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

MS21083C8

Purchased

No

250

Each

94.0000

2

NUT

## Location

## Loc Qty

## Loc Code

304

39

121185

22

121349

17

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

250.0000

WASHER

Location

Loc Qty

Loc Code

ST297

250

114915 ✓

250

NAS1149D0863J

Purchased

No

250

Each

221.0000

WASHER

Location

Loc Qty

Loc Code

ST298

221

118078

34

119307

1

120308

86

121556

100

NAS1515H3L

Purchased

No

230

Each

311.0000

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

271

118686

3

120360

11

121556

57

122151 ✓

200

NAS1611-005

Purchased

No

230

Each

140.0000

O-RING

Location

Loc Qty

Loc Code

FP001

140

106099

18

114220 ✓

46

119438

36

121415

40

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 87012

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

416.0000

8

8

O-RING

8

8

12/07/25

## Location

## Loc Qty

## Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151 ✓

300

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1) REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS, INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	RAH	PORT HADLOCK, WA	
CHECKED	AK	DRAWING NO.	REV. F
MFG APPR.	AK	D2750	SHEET 1 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

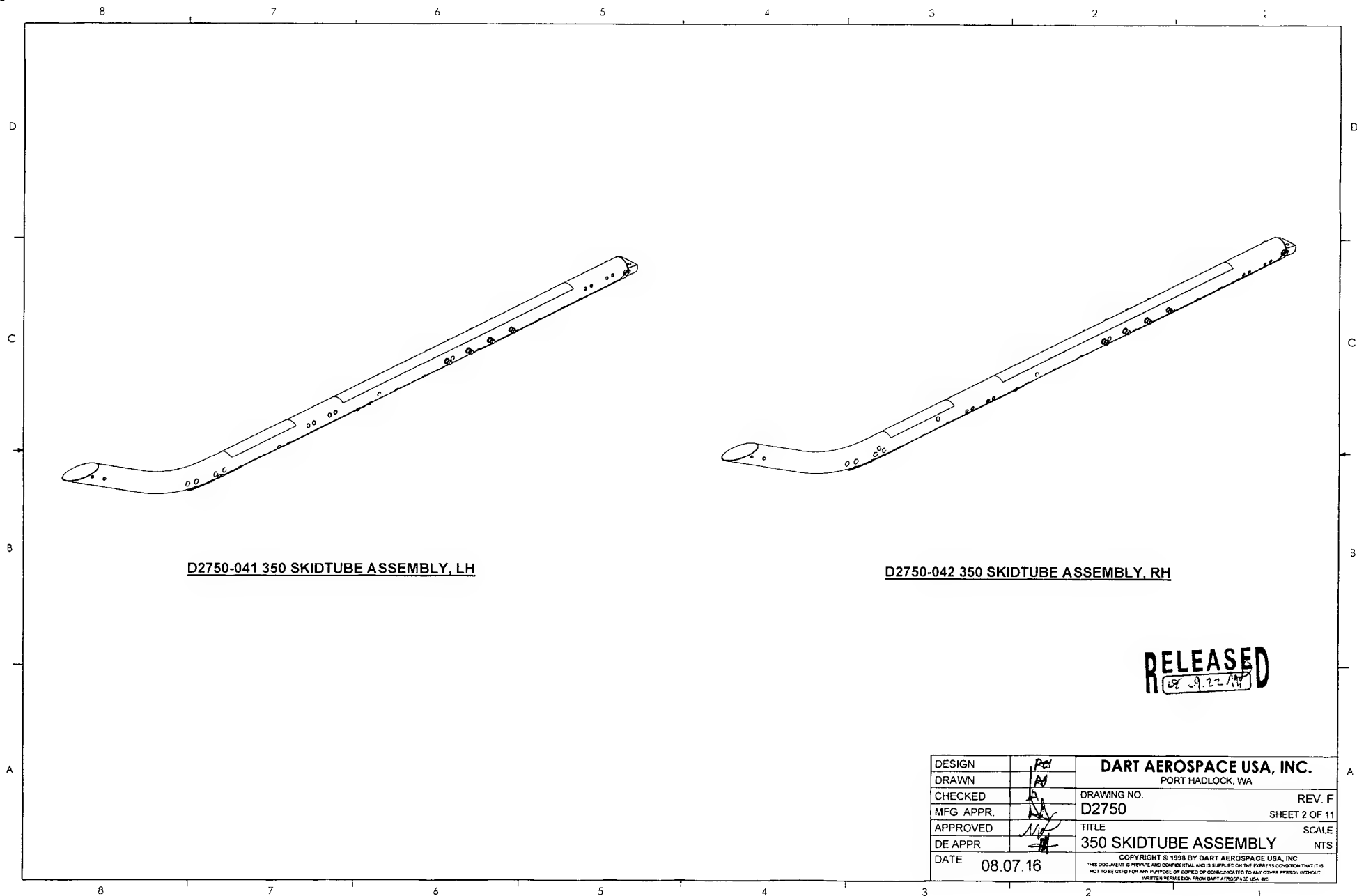
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
 08.22.16

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
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**Dart Aerospace Ltd**

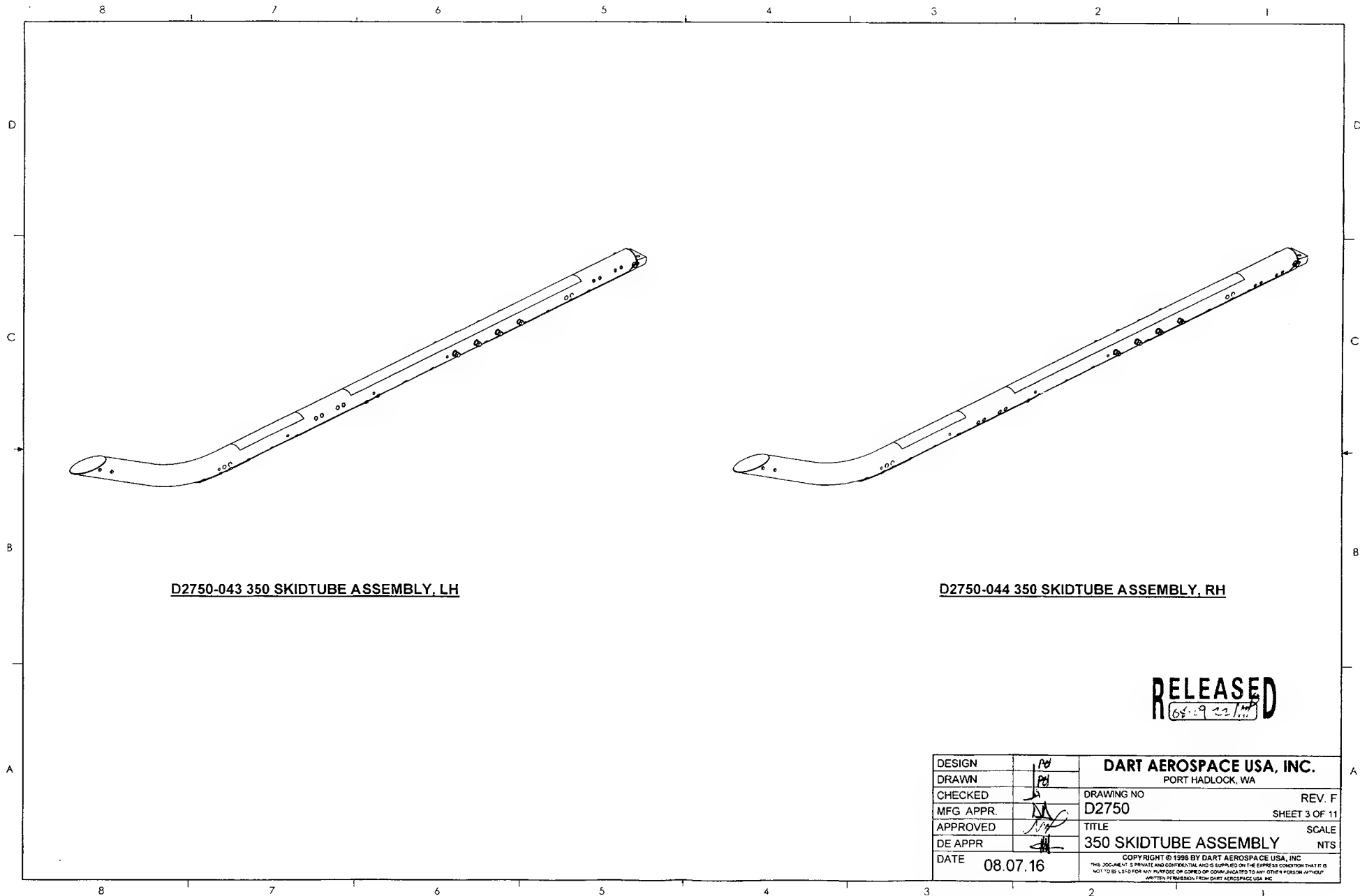
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





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DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO	REV. F
MFG APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR	NA	350 SKIDTUBE ASSEMBLY	NTS
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# Dart Aerospace Ltd

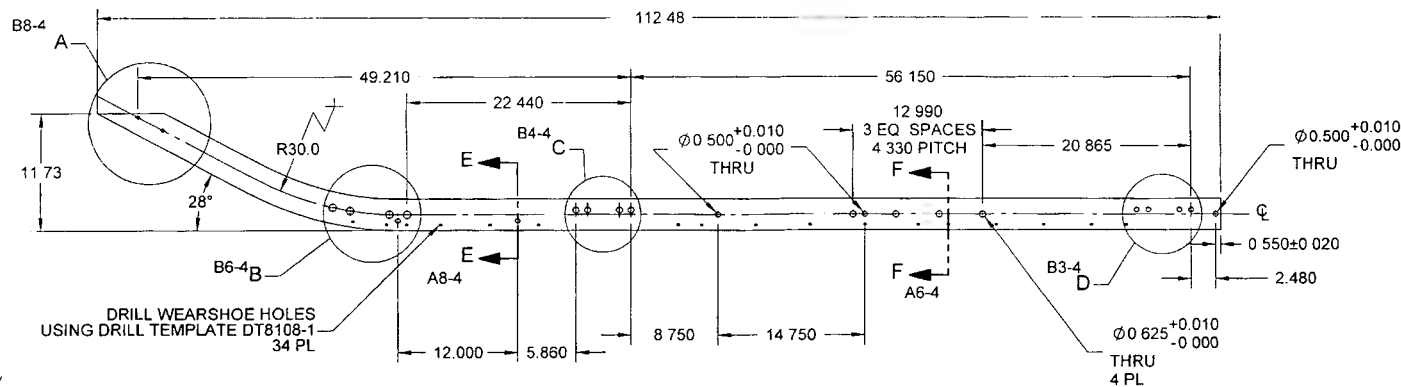
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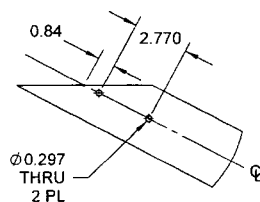
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

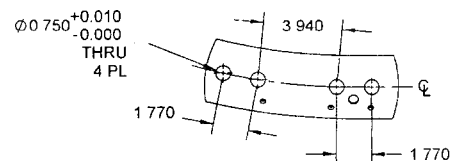
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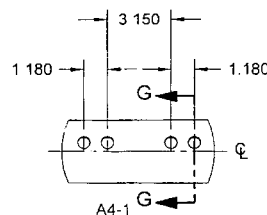
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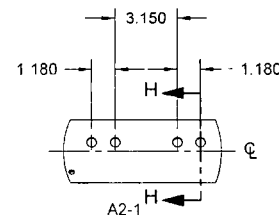
**DETAIL A**  
SCALE 2X



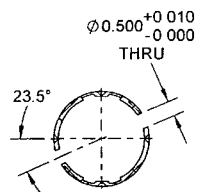
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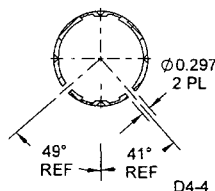
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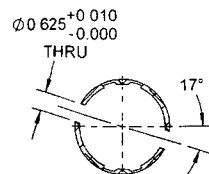
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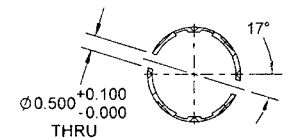
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	
DRAWN	
CHECKED	
MFG APPR	
APPROVED	
DE APPR	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
SHEET 4 OF 11  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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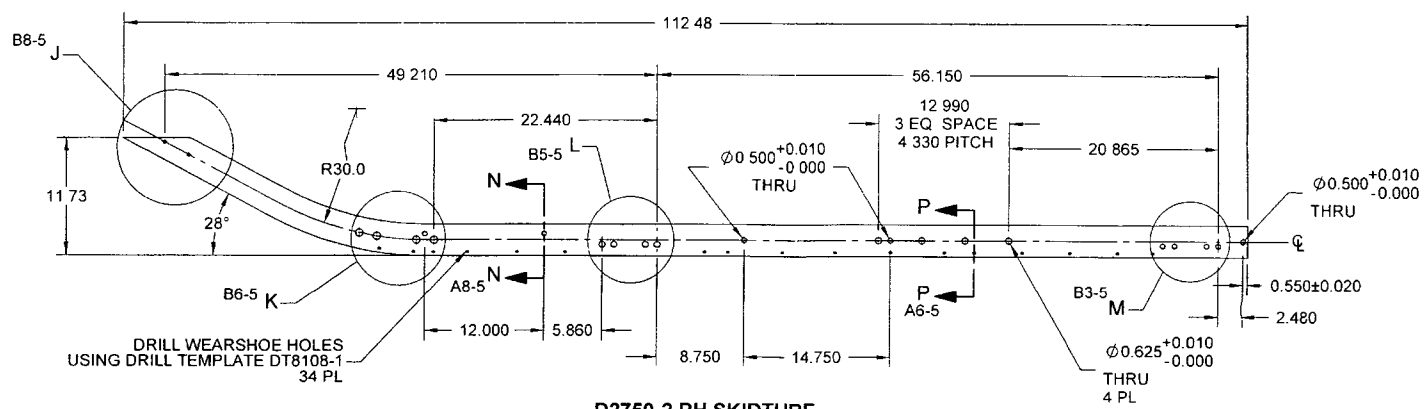
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

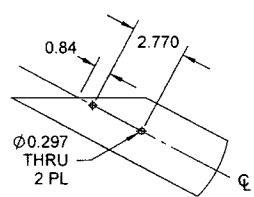
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

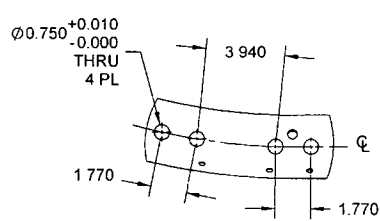
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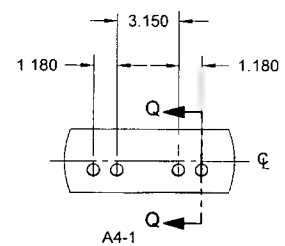
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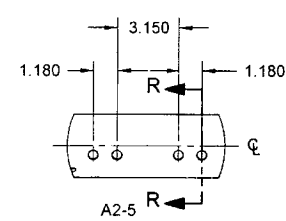
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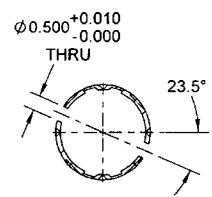
**DETAIL K**  
SCALE 2X



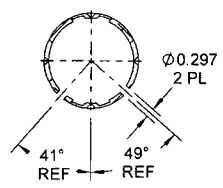
**DETAIL L**  
SCALE 2X



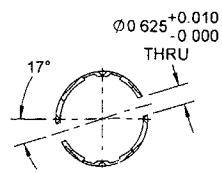
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SCALE 2X



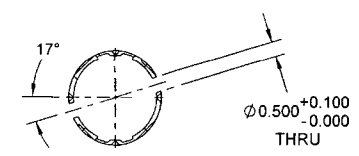
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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08-07-16

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
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MFG APPR.	PA	D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

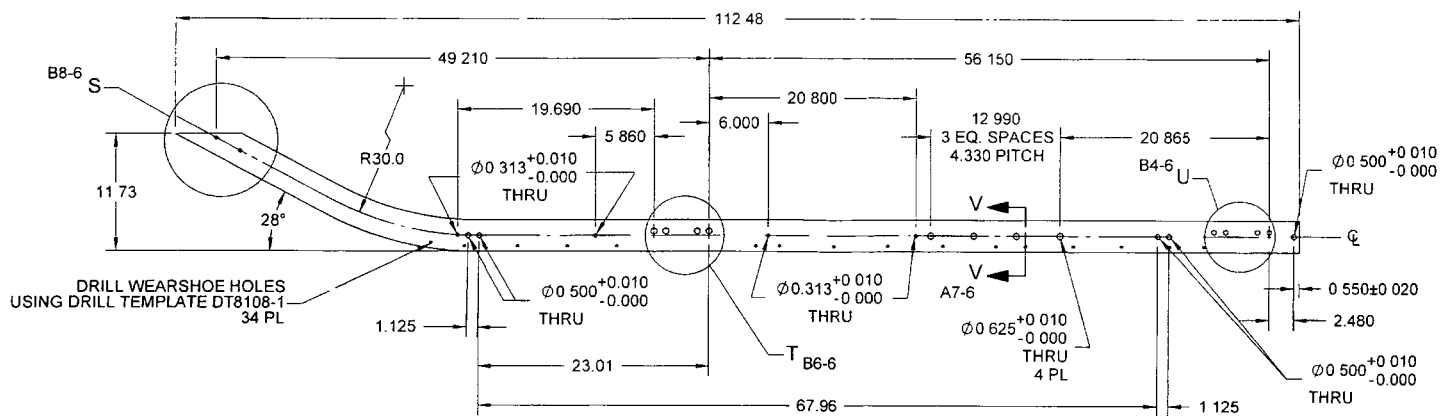
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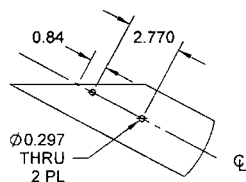
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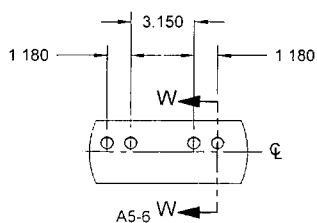
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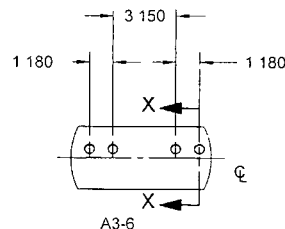
### D2750-3 LH SKIDTUBE



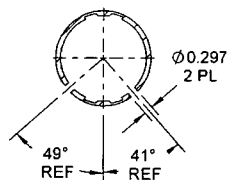
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SCALE 2X



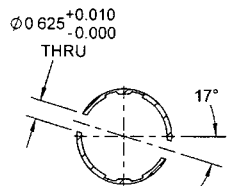
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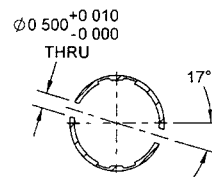
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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08/07/16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
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MFG. APPR		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
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1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

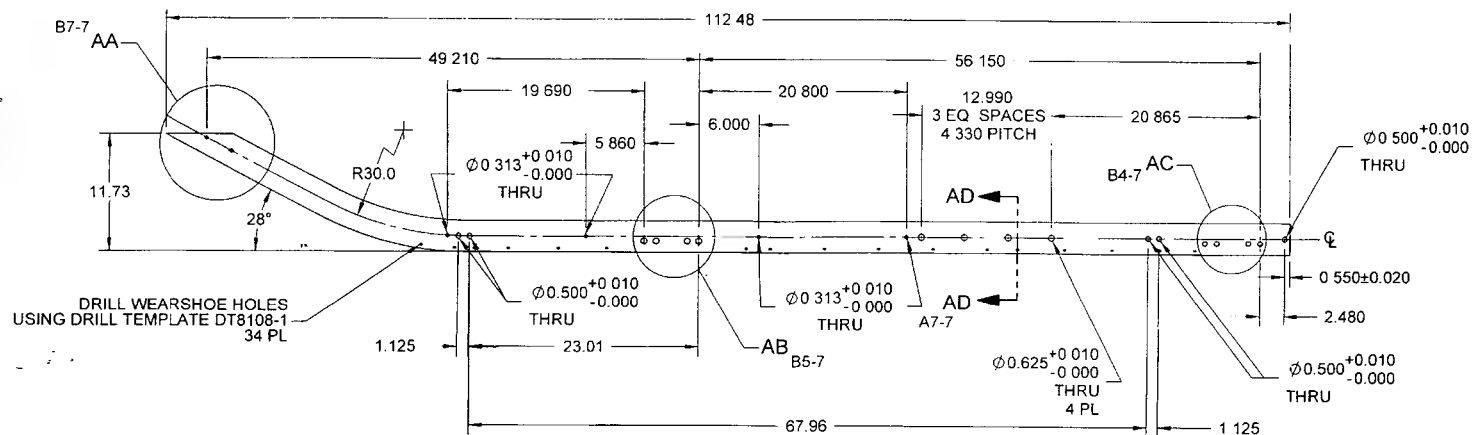
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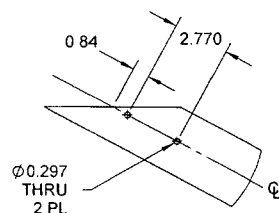
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

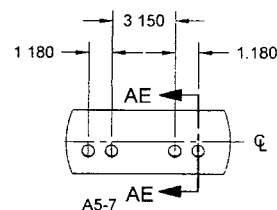




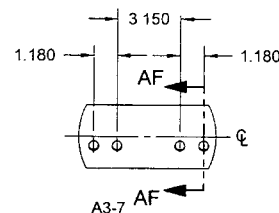
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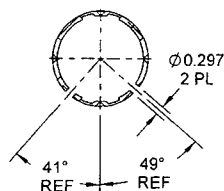
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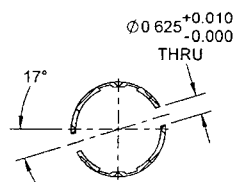
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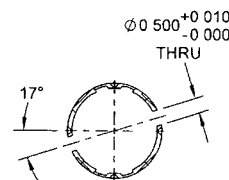
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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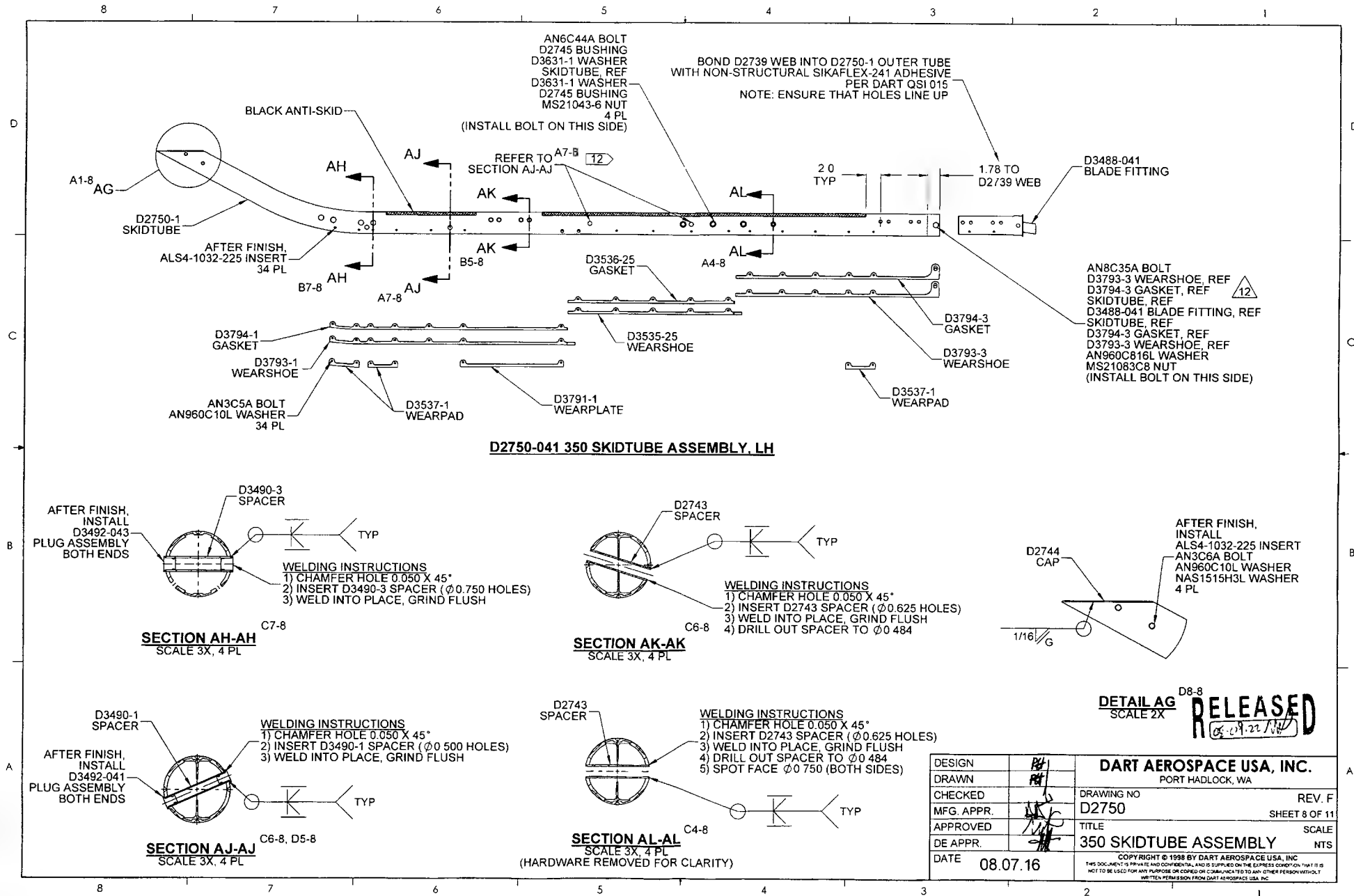
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

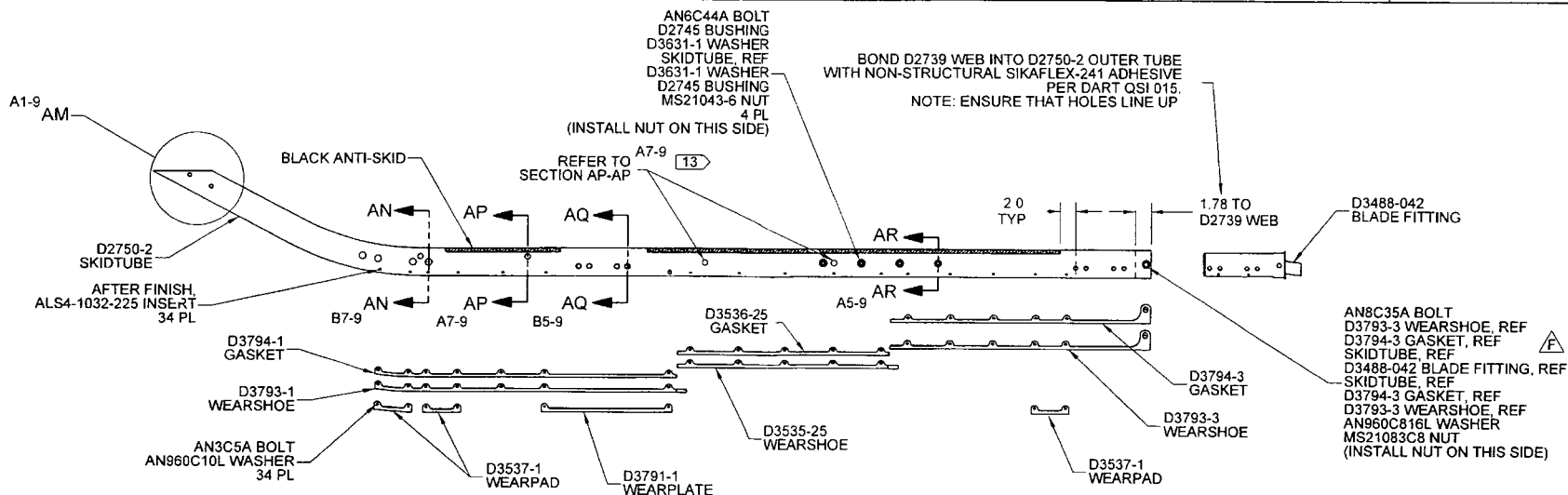
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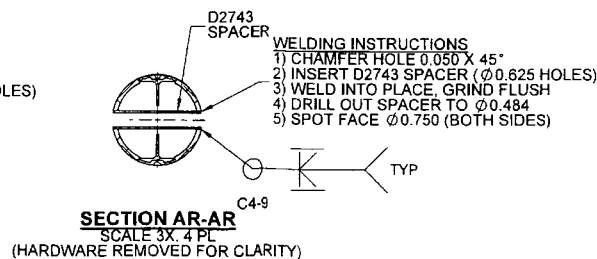
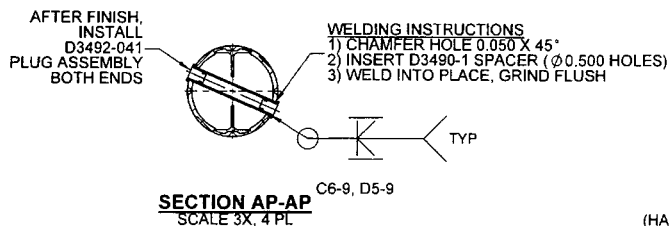
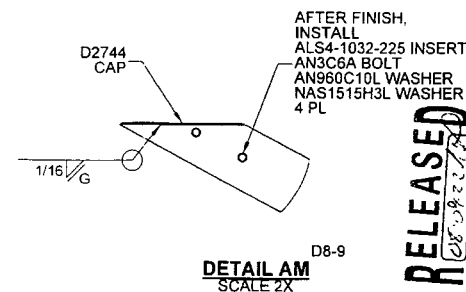
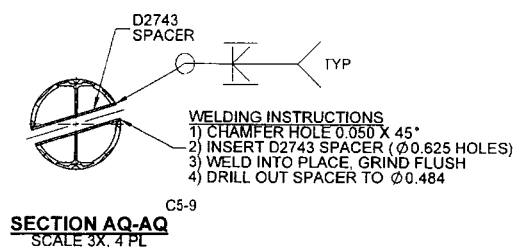
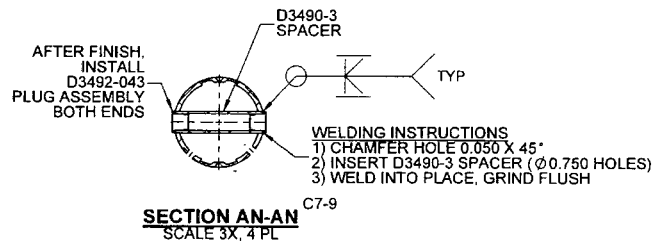
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



# **D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	DART AEROSPACE USA, INC.	REV. F
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	SHEET 9 OF 11
MFG. APPR.		TITLE	SCALE
APPROVED		350 SKIDTUBE ASSEMBLY	NTS
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08-09-2017

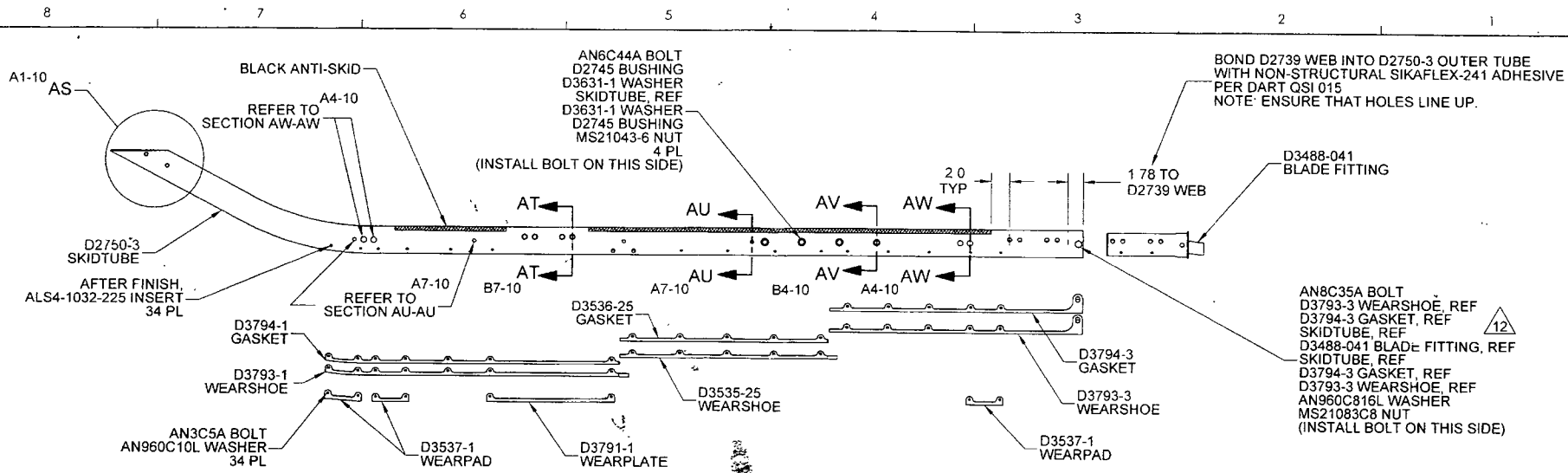
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

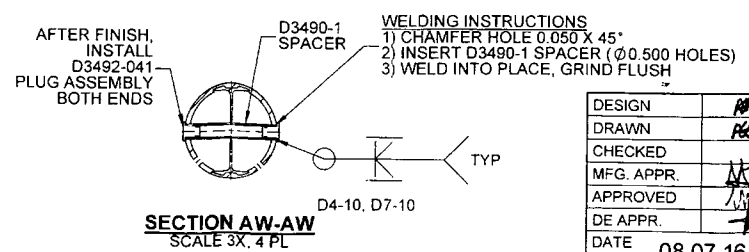
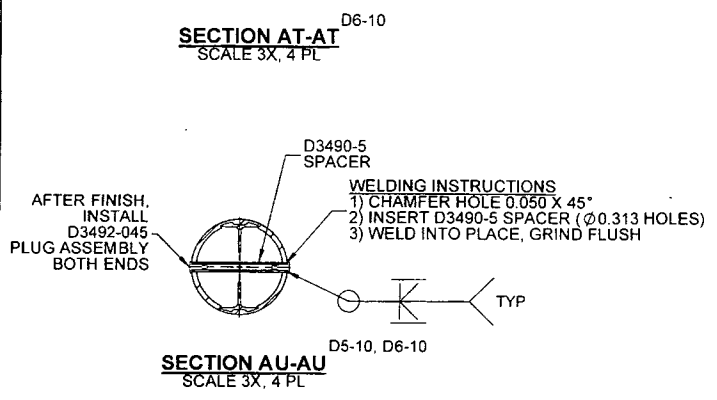
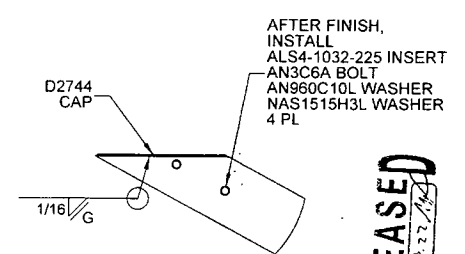
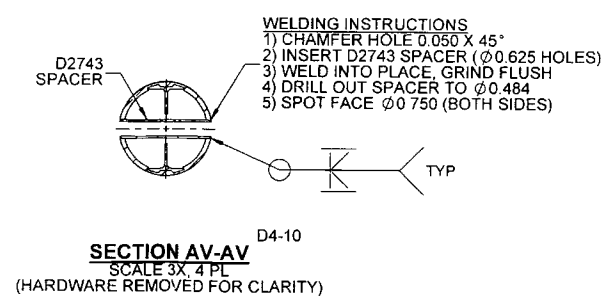
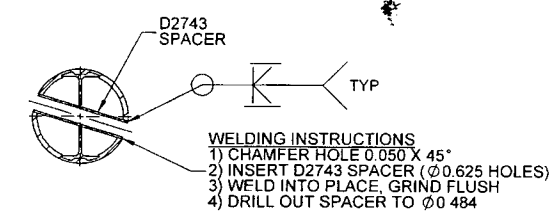
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED	REV	DRAWING NO.	REV. F
MFG. APPR.	REV	D2750	SHEET 10 OF 11
APPROVED	REV	TITLE	SCALE
DE APPR.	REV	350 SKIDTUBE ASSEMBLY	NTS
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**RELEASED**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

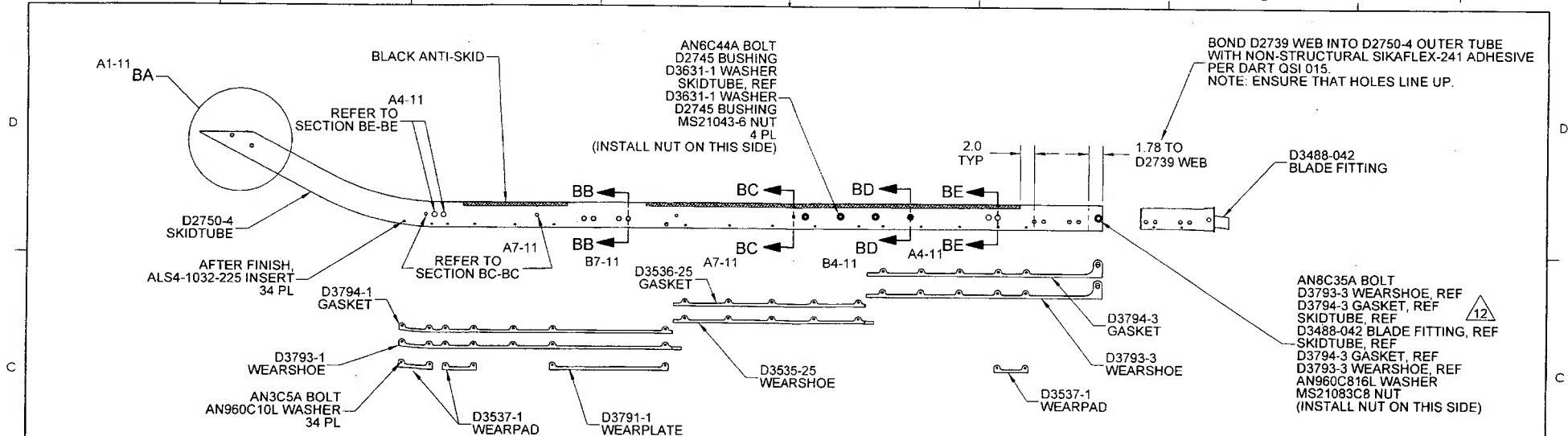
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

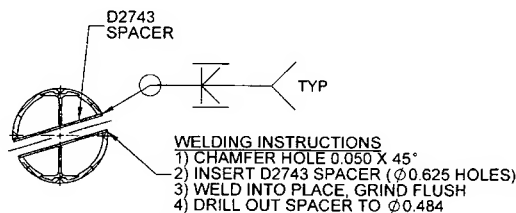
NOTE: Date & initial all entries



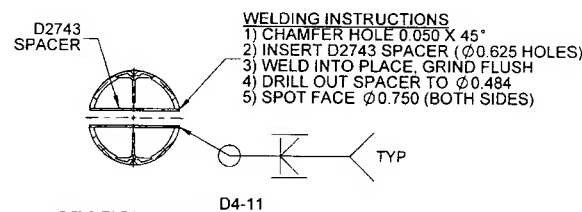
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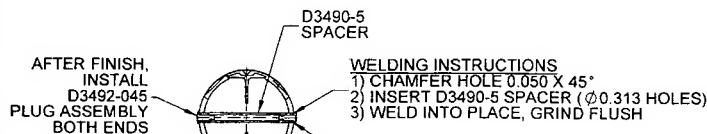
### D2750-044 350 SKIDTUBE ASSEMBLY, RH



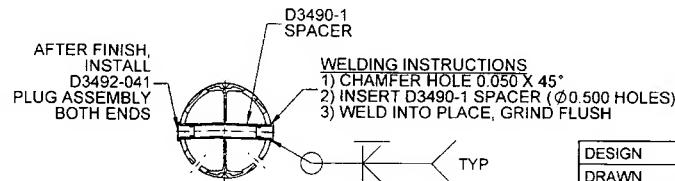
#### SECTION BB-BB SCALE 3X, 4 PL



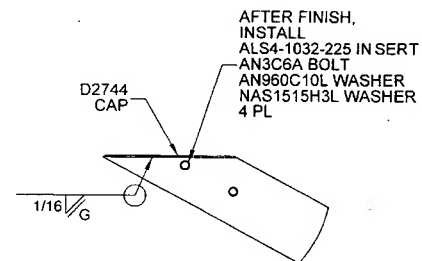
#### SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



#### SECTION BC-BC SCALE 3X, 4 PL



#### SECTION BE-BE SCALE 3X, 4 PL



#### DETAIL BA SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 298

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: 87012  
Part #: A350-636-014  
Description: Skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Penetration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Fusion:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier David Reed Date of Test Coupon 12.07.23

Welder Barclay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld